

5/11

DART AEROSPACE LTD	Work Order:	22561
Description: Main Body	Part Number:	D3400-1
Dwg: D3400 Rev. A page 4	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	05.02.28	10
2	MV	Cut blank: 1.500" x 3.000" x 4.450" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B3.000x01.500) Identify for D3400-1 Batch: M16530	SA	05.02.28	10
3	MV	Machine D3400-1 as per Folio FA516 and Dwg D3400 Identify as D3400-1	SD	05.03.01	10
4	QC2	Inspect parts as they come off the CNC machine	SD	05.03.01	10
5	QC8	Second check	ml	05/03/01	10
6	MV	Deburr	SD	05.03.01	10
7	QC5	Inspect work to Step 6	ml	05/03/01	10
8	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05/05/11	10
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask all holes	FC	05 05 20	10
10	QC3	Inspect Powder Coat	ML	05 06 20	10
11	ST	Identify and Stock	CL	05/07/04	10
12	AC	Cost / part 2484	A	05/07/05	10
13	DC	Close W/O 2484 Inspect Level 21	JA	05.07.15	10

Rev	Date	Change	Revised By	Approved
A	05.02.24	New issue	KJ/JLM	1/4/

RELEASED
05/05/0227

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

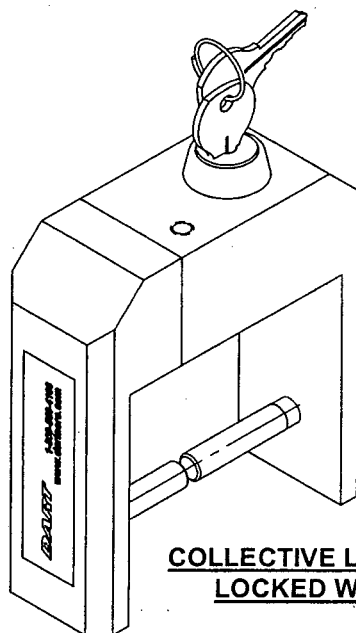
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

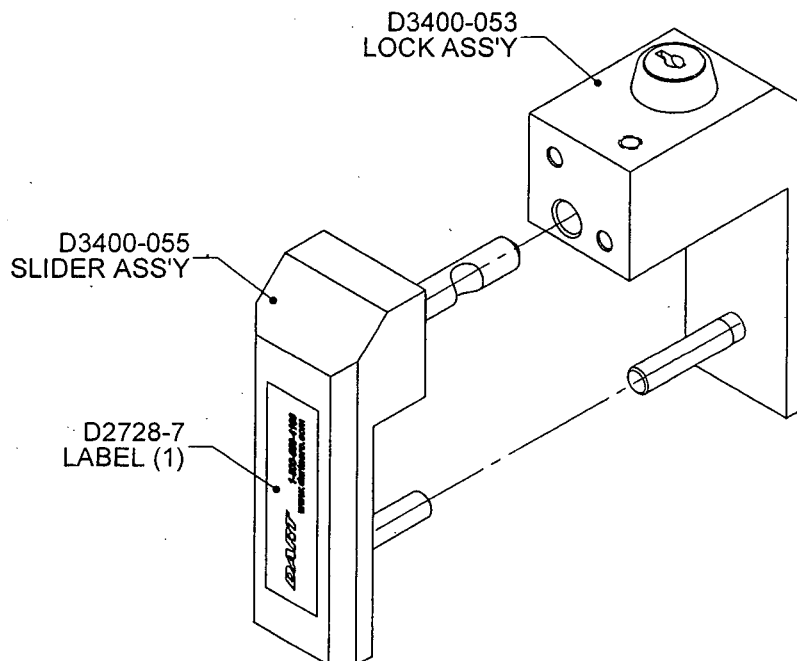
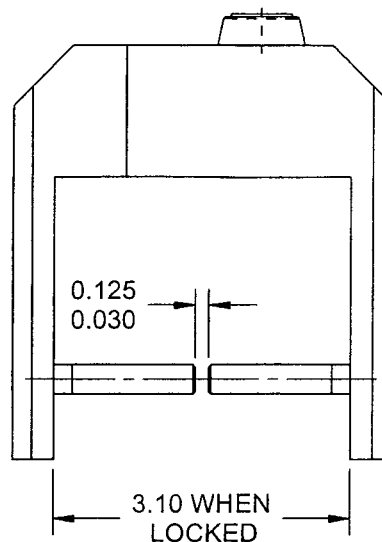


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. A SHEET 1 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.02.23	NEW ISSUE	

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05/04/23



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



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NO. 22561**

D3400-051 AS355 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

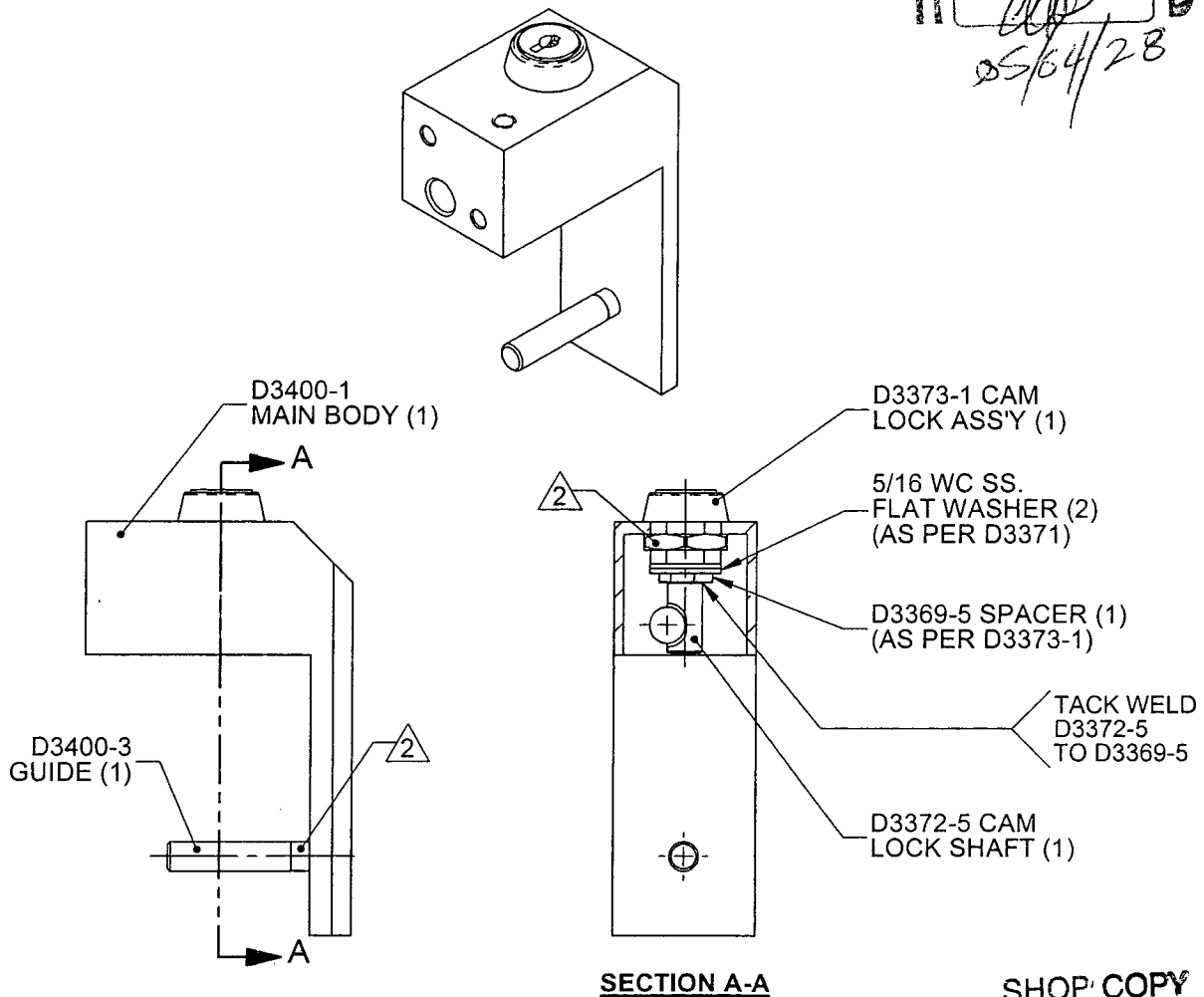
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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D3400-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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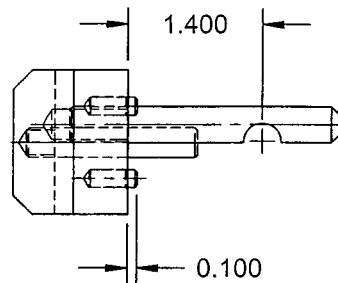
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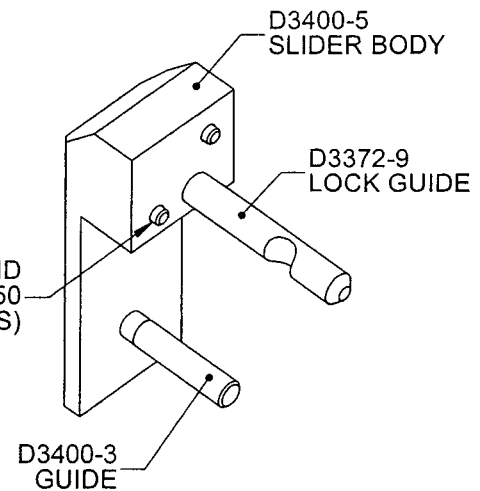
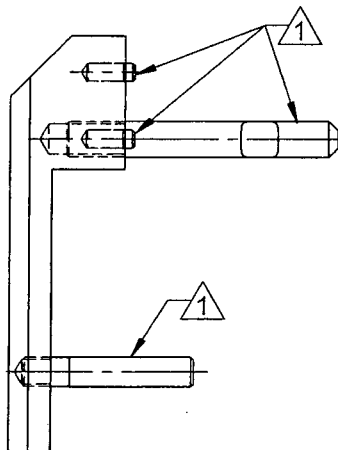


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3400	REV. A SHEET 3 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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STD. GROUND
DOWEL PIN $\varnothing 3/16 \times 0.50$
(2 PLACES)



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D3400-055 SLIDER ASS'Y

NOTES:

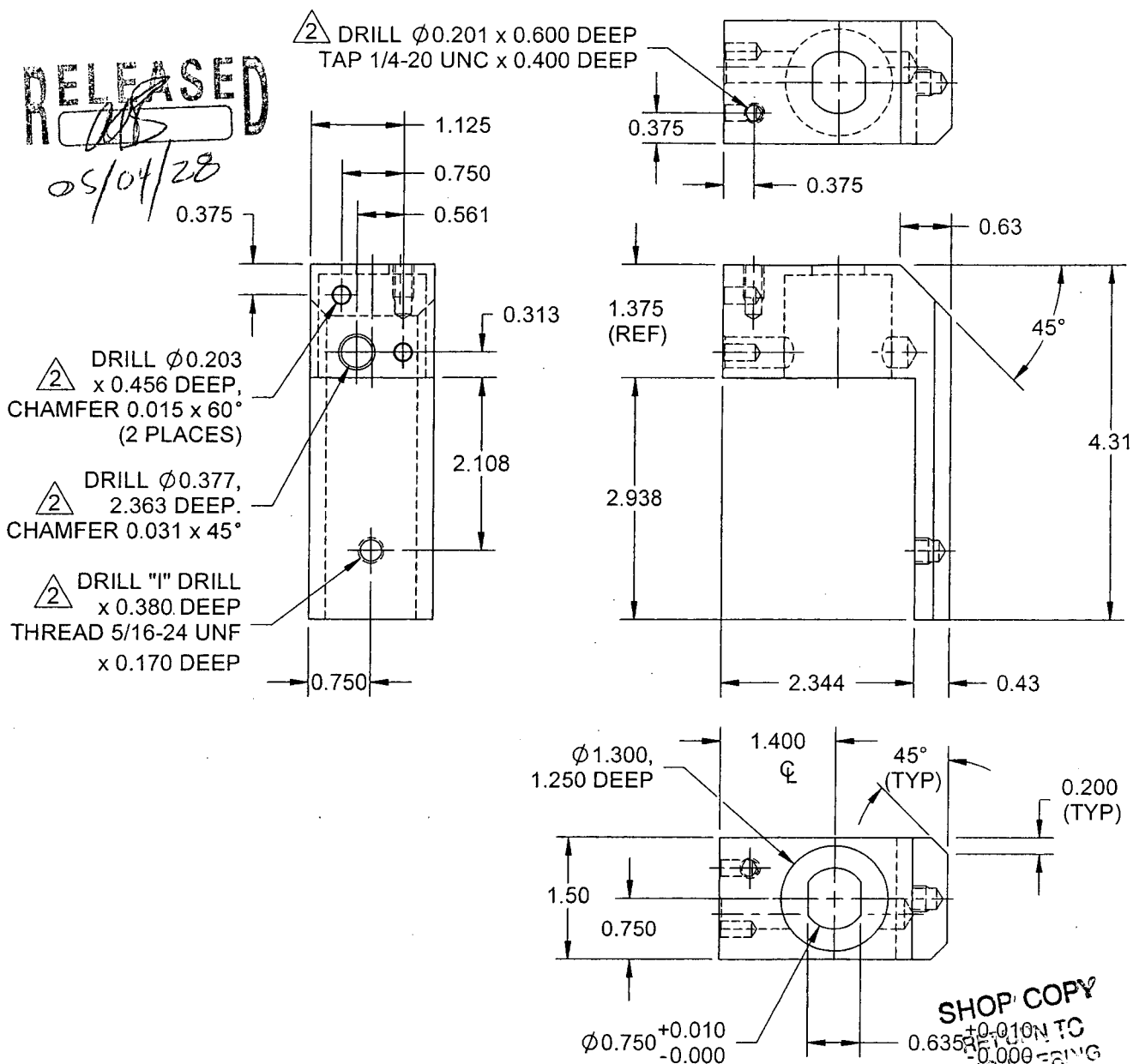
- 1) COVER DOWEL PIN (2 PLACES), D3400-3 AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3400	REV. A SHEET 4 OF 6
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



D3400-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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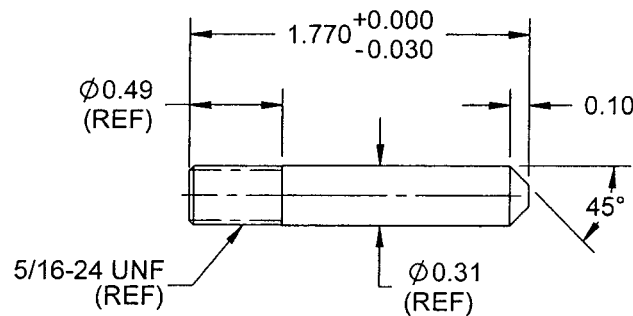
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING

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[Signature]
05/04/28



D3400-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-17A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

NO. 22561

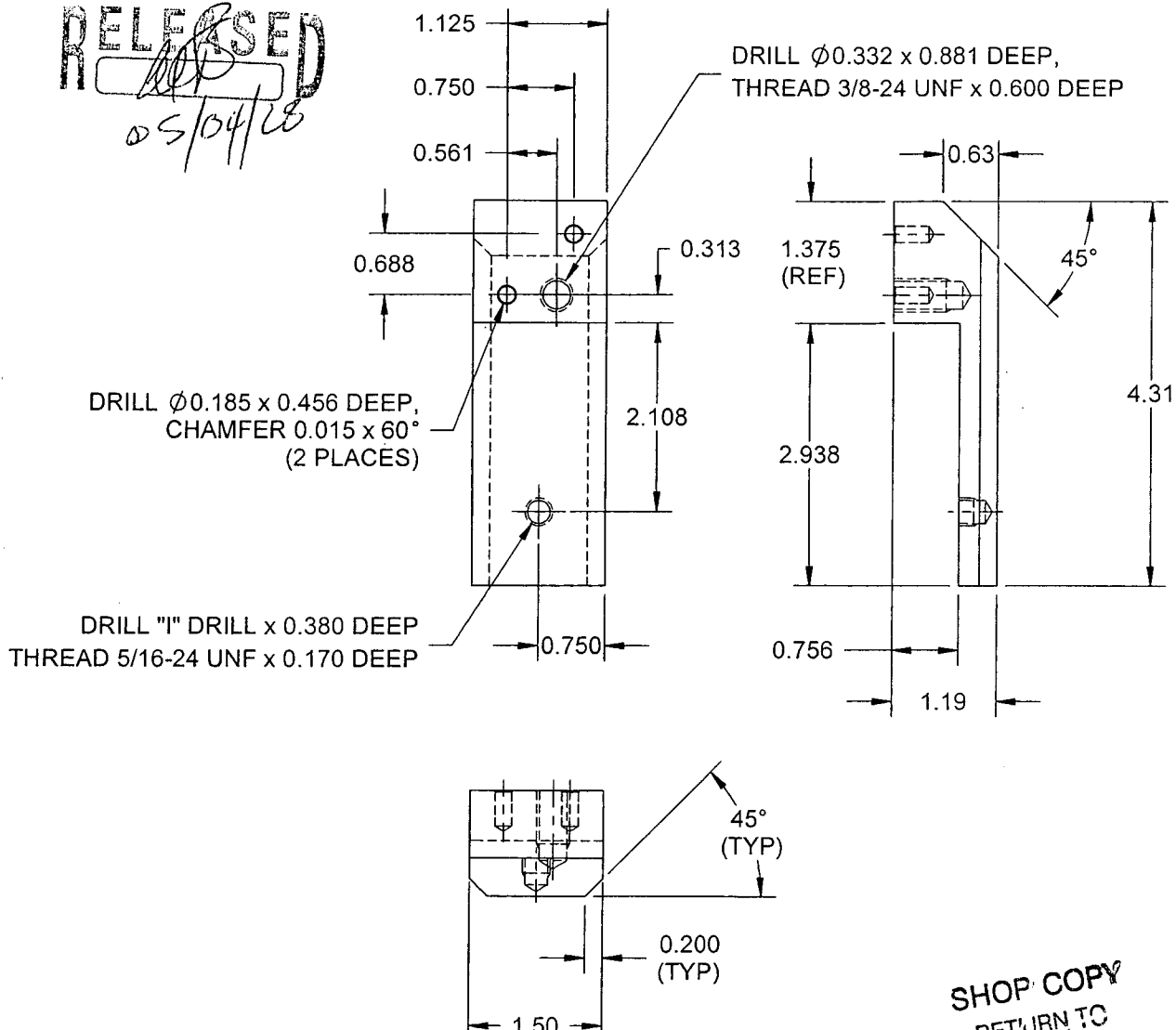
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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05/04/23



D3400-5 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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PART AEROSPACE LTD		Work Order: 22561
Description:		Part Number: 03400-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.375		.373	✓			
.375		.373	✓			
.750		.748	✓			
.786						Cannot measure
.313		.311	✓			
2.108		2.108	✓			
.625		.625	✓			
45°		45°	✓			
4.31		4.318	✓			
.43		.434	✓			
2.344		2.348	✓			
2.938		2.931	✓			
1.375		1.380	✓			
Ø 1.300		1.307	✓			
1.250		1.253	✓			
1.400		1.398	✓			
.200		.207	✓			
.635	+ .010 - .030	.643	✓			
Ø .750	+ .010 - .000	.753	✓			
.750		.750	✓			
1.50	± .030	1.496	✓			

Measured by: SP	Audited by: ml	Prototype Approval:
Date: 03.03.01	Date: 05/03/01	Date: N/A

Rev A	Date:	Change New Issue	Revised by KJ/JLM	Approved
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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 24, 2005
03:25 pm

Work Order No : 0022561
Project Name : D3400-1
Project For : WK511
Work Order Type : Main
Main WO Number :
House Part Number : D3400-1
Description : Main Body
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 02-24-05
Est Finish Date : 03-04-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00